



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Handwritten signature: AAP

RBEL135M-2905-101-01
Job Sheet 188361



Part No: RBEL135M-2905-101-01 Job Qty: 4 ea

Part Name: Case



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/8/19

Job Tracking No:

Due Date: 1/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEL135M-2905-101 REV 9 IPP REV A 18.05.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/24/19	1/24/19	0.00	0.00	Start Up Machining-3		J.C.L. 19-01-09
110	CNC Vertical Machining	4 pcs	1/24/19	1/24/19	0.00	2.00	NV5000-1		J.C.L.
120	QC	4 pcs	1/24/19	1/24/19	0.00	0.00	QC2 Machining-4		J.C.L. 19-01-15
130	QC	4 pcs	1/24/19	1/24/19	0.00	0.00	QC8 Machining-4		19/01/15
150	Outsource	4 pcs	1/24/19	1/24/19			ATG001-VC	5	JAN 22 2019
160	Packaging	4 pcs	1/24/19	1/24/19	0.00	0.00	Packaging2		38
170	QC	4 pcs	1/24/19	1/24/19	0.00	0.00	QC6		38
180	Packaging	4 pcs	1/24/19	1/24/19	0.00	0.00	Packaging3-1		38
190	QC21-SA	4 Ea	1/24/19	1/24/19	0.00	0.00	QC21		38

Part Op 90 - Cut blank at 9.200"

Descriptions: 110 - 1-Machine as per folio FC 573 FOLIO REV: AA DWG REV: 9 2-Debur ***
FIXTURE LOCATION A6 ***
150 - -Issue P/O to Groupe Altech; PO 04253 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2
CLASS 1, Water sealant -Certificate of Conformity is required
160 - C of C is required.

GA135

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S1.250X6.000	6061T6 PLATE 1.250 X 6.000	3.0800 ft (.77 ea)	90-Start up Operation	5080896

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S1.250X6.000	3	12	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S143285



Part: RBEL135M-2905-101-01

Job No: 188361

Serial No/Batch: S143285

Revision: 9

Inspector:

Exp Date:

Instructions:

Date: 01/09/19

Part Specifications

Specifications could not be found.

Plex 1/8/19 2:49 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

DART AEROSPACE LTD		Work Order:	188361
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.998	±.005	8.997	✓		Caliper	
4.331	±.005	4.335	✓		Caliper	SCL-08
2.439	±.005	2.440	✓			
2.047	±.005	2.051	✓			
2.186	±.005	2.180	✓			
Ø4.731	±.005	4.728	✓			
Ø5.198	±.005	5.201	✓			
Ø5.671	±.005	5.677	✓			
M6x1.0-6H	N/A	O.K.	✓		60 Nm-60	
1.498	±.005	1.500	✓		Caliper	SCL-08
Ø1.179	±.005	1.1795	✓		Bore Gauge	
1.276	±.005	0.277	✓		Caliper	SCL-08
Ø.985	±.005	0.989	✓			
Ø3.663	±.005	3.663	✓			
Ø3.206	±.005	3.205	✓			
Ø2.207	±.005	2.204	✓			
1.674	±.005	1.675	✓			
1.228	±.005	1.228	✓			
.709	±.005	0.709	✓			
.584	±.005	0.585	✓			
.473	±.005	0.473	✓			
.125	±.005	0.125	✓			
.348	±.005	0.349	✓			
5.272	±.005	5.273	✓			
2.636	±.005	2.636	✓			
R1.362	±.005	1.362	✓			
1.693	±.005	1.693	✓			
.237	±.005	0.239	✓			

Measured by: J.C.-L.	Checked by:	QC Inspector:
Date: 14-01-13	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

1.1807" BEARINGS

Technical drawing of a mechanical part, likely a propeller hub, showing a cross-section with various dimensions and features. The drawing includes a central circular hole, a larger outer circular flange, and a complex, curved outer profile. Key dimensions include overall height (8.998), outer diameter (Ø 5.671), inner diameter (Ø 2.207), and various radii (R.13, R.31, R.99). The drawing also shows fillet radii (R.13, R.31, R.99) and chamfers (2X 15°, 2X 10°). The part is labeled 'M6X1.0 - 6H THRU ALL' and 'B.C. Ø 5.198'. The drawing is a cross-section, indicated by the 'C' symbol.

Dimensions and Features:

- M6X1.0 - 6H THRU ALL
- B.C. Ø 5.198
- Ø 5.671
- Ø 4.731
- 2X Ø 1.498
- 2X Ø 1.180
- Ø 1.179
- (P.F. -27)
- Ø .985 THRU
- 2X 15°
- 2X 2.047
- 2.439
- 2X 2.186
- (2X) (13°)
- 2X R.31
- 2X R.99
- 2X 10°
- Ø 2.207
- B.C. Ø 3.206
- Ø 3.663
- 2X 2.835
- 8.998
- 4.331
- 1.674

Technical drawing of a vertical shaft assembly. The drawing shows a shaft with several components and dimensions. The dimensions are as follows:

- 1.228 (Total length)
- .709 (Distance from top to first component)
- .584 (Distance from top to second component)
- .348 (Distance from top to third component)
- 2X .125 (Two components, each .125 units thick)
- .473 (Distance from bottom to last component)

The drawing includes a cross-section of the shaft, showing a central hole and a flange. The text "ENGRA" and "MADE" is visible on the right side of the drawing.

ENGRAVE T/N, S/N,
"MADE IN USA"

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188361 M05

		REV 9	
TITLE HYDRAULIC PUMP DRIVE TOOL			
DWG NO. RBEL135M-2905-101-01			
MAT'L 6061		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
REAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH CLEAR ANODIZE		.XXX ± .01 ANGLES ± 5°	
SPEC MIL-A-8625F, TYPE II, CLASS I		1. BREAK ALL SHARP EDGES ± 1/32"	
DRAWN BY: PERRITT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED: DUERFELDT		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPSS APPR: ANDERSON		USED ON MODEL	
QA APPR: LINDSAY		EUROCOPTER EC135	
APPROVED: MACKOVJAK			
SCALE 1:2	DATE 4/23/2010	SHEET 3 OF 18	

1.345

18-01-08



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042283



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042283
PO Date: 1/15/19
Due Date: 1/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188439	D2224	Rappel Anchor Assembly : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O: _____ Red Anodize as per Dwg D2224 MIL-A-8625	Firmed	-	1/22/19	4 pcs	0 pcs	4 pcs	\$17.04/pcs	\$68.16
2	187890	646.9910	Struts Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	-	1/22/19	10 pcs	0 pcs	10 pcs	\$12.49/pcs	\$124.90
3	188363	RBEL135M-2905-101-05	Top Cover -Issue P/O to Groupe Altech; PO _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	1/22/19	4 pcs	0 pcs	4 pcs	\$17.04/pcs	\$68.16

Line Item Note: ** asap : (**



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PURCHASE ORDER

PO042283



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	188361	RBEL135M-2905-101-01	Case C of C is required. -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	1/22/19	4 pcs	0 pcs	4 pcs	\$17.04/pcs	\$68.16

4 x

JAN 22 2019

38
-89

Line Item Note: *asap please :(*

Grand Total: \$329.38

Order Notes

- Procurement Quality Clauses
- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable)
- A022 Apical Processing
- A024 process certifications
- A026 certification of material conformance
- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents
- A048 counterfeit parts avoidance, detection, mitigation and disposition program
- A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/18/19 2:33 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917053

Date: 17-Jan-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 4 ea	Part: RBEL135M-2905-101-05 ✓ Top Cover Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24488	Rev: 9 PO: PO042283 ✓ Line: 3	
✓ 4 ea	Part: RBEL135M-2905-101-01 ✓ Case Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24490	Rev: 9 PO: PO042283 ✓ Line: 4	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/1/19</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.